

# Work Order ID 62438

Frida, October 01, 2010 10:26:59 AM

Page 1

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-016 CHG 001

S. Solu124

for BG 10-11-24

1362438

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62438



Page 2

Friday, October 01, 2010 10:26:59 AM

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning. *(ALL holes as per dwg D4168)*

6- Drill pilot holes as per Dwg <sup>4168</sup> D2750 sheet # <sup>5</sup> (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail <sup>K</sup> B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail <sup>K</sup> B  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for Detail <sup>K</sup> B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

~~9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".~~

*N/A*

10- Open up holes of Detail <sup>3</sup> A to 0.297" (total of 2 holes per side) *+201 1 place per side*

*10-10-13*

*10-10-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62438

Friday, October 01, 2010 10:26:59 AM



Page 3

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, RH

Stop



Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐ 17115 778

12-Grind welds flush as per Dwg D2750

BE 10/11/03  
BE 10/11/03

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/10/04

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10/04

(F)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62438**

Friday, October 01, 2010 10:26:59 AM



Page 4

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

DP

10-11-4



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

BE 10-11-04



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 62438**

Page 5

Friday, October 01, 2010 10:26:59 AM

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail <sup>L</sup> and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750. 41682-Open up holes of Detail <sup>K</sup> to 0.750" (total of 4 holes per side)  
as per dwg D2750. 4168

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail <sup>K, L</sup> B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8) 4168

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 116040 ☐☐☐  
exp. date: 11/09/308- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod batch: 11157789- At section <sup>AP-AP</sup> 20-21 drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

4168

DP 10-11-4

BB 10/11/05

10-10-13

BE 10/11/08  
BE 10/11/08  
BE 10/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62438

Friday, October 01, 2010 10:26:59 AM



Page 6

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

BE 10/11/09

BE 4168 C-BORE SECTION CH-CH 4 PLACES BE 10/11/09

12-Deburr holes

BE 10/11/09

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

8101069

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

8101069

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62438

Friday, October 01, 2010 10:26:59 AM



Page 7

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

=> ul 10/11/10

xl q

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115291

Memo

0.00

Powder Coating

START TIME: 1:40

OVEN TEMPERATURE: 320

FINISH TIME: 2:10

1 BR 10-11-11

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

=> ul 10/11/23

1 q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62438

Friday, October 01, 2010 10:26:59 AM



Page 8

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, RH

Stop



Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing								
HandFinish	Memo	0.00				1	0		
Hand Finishing	1- Install inserts as per Dwg D2750 4168								
230		0.00							
	HandFinishing								
HandFinish	Memo	0.00				1	0		
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: N/A								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 11115114 EXP DATE: 1110								
	4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: 11114189								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 11114596								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 62438**

Friday, October 01, 2010 10:26:59 AM



Page 9

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
250  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62438**

Friday, October 01, 2010 10:26:59 AM



Page 10

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-016 Location: <u>72</u> PPP rev: <u>1A</u>								
280 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/11/24

10/11/24

MF

10-11-24.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:03 AM

Page 1

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH




Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																			
D3490-1  Cross Bolt Spacer		Manufactured	No			160	Each	41.0000	4	4																																																						
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="10"></td></tr><tr><td>LG</td><td>41</td><td></td><td colspan="10"></td></tr><tr><td>59424</td><td>3</td><td></td><td colspan="10"></td></tr><tr><td>61217</td><td>38</td><td></td><td colspan="10"></td></tr></table>													<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>											LG	41												59424	3												61217	38											
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																																														
LG	41																																																															
59424	3																																																															
61217	38																																																															
D3490-3  Cross Bolt Spacer		Manufactured	No			160	Each	2.0000	4	4																																																						
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="10"></td></tr><tr><td>LG</td><td>2</td><td></td><td colspan="10"></td></tr><tr><td>60294</td><td>1</td><td></td><td colspan="10"></td></tr><tr><td>61218</td><td>1</td><td></td><td colspan="10"></td></tr></table>													<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>											LG	2												60294	1												61218	1											
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																																														
LG	2																																																															
60294	1																																																															
61218	1																																																															
AN3C34A  BOLT		Purchased	No			230	Each	20.0000	1	1																																																						
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="10"></td></tr><tr><td>ST353</td><td>20</td><td></td><td colspan="10"></td></tr><tr><td>115767</td><td>20</td><td></td><td colspan="10"></td></tr></table>													<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>											ST353	20												115767	20																								
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																																														
ST353	20																																																															
115767	20																																																															

4 BE 10/11/08

262451 4 BE 10/11/08

21 10/11/23

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:03 AM

Page 2

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased No

230 Each

77.0000

4 4



BOLT



9/10/11/23

## Location

## Loc Qty

## Loc Code

ST353

77

M115882

101261

4

109771

18

115358

15

115518

40

AN3C37A

Purchased No

230 Each

63.0000

1



BOLT



9/10/11/23 SP

## Location

## Loc Qty

## Loc Code

ST354

63

111775

1

114761

12

114801

50

AN3C42A

Purchased No

230 Each

107.0000

1



BOLT



9/10/11/23 SP

## Location

## Loc Qty

## Loc Code

ST354

107

106169

7

106176

100

D3488-042

Manufactured No

230 Each

8.0000

1



Blade Fitting Assembly, RH



9/10/11/23

## Location

## Loc Qty

## Loc Code

FP008

8

1361690

59643

8

Friday, October 01, 2010 10:27:03 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O: 62438		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/24	#100	Item change Fix Parting numbers for An3c 37A + An3c 42A	MA	10.11.24			5 10/12/24

Part No: D350-636-016 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Friday, October 01, 2010 10:27:03 AM

Page 3

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

230

Each

119.0000

7

7



Bushing



10/11/23

## Location

## Loc Qty

## Loc Code

ST092

40

62197

40

ST093

79

57615

79

X7

D4154-041

Manufactured No

230

Each

0.0000

1

1



Wearplate Assembly

B63871



10/11/23

D4170-1

Manufactured No

230

Each

0.0000

4

4



Bushing



862669 10/11/23

D4171-1

Manufactured No

230

Each

0.0000

1

1



Bushing

B62710



10/11/23

MS21043-3

Purchased No

230

Each

2,599.000

5

5



Nut



10/11/23

## Location

## Loc Qty

## Loc Code

FG

76

103691

76

ST301

2523

111383

46

112314

2477

X5

Friday, October 01, 2010 10:27:03 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:03 AM

Page 4

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Purchased

No

230

Each

5,838.000

9

9



Washer



*Handwritten: 10/11/27*

Location

Loc Qty

Loc Code

ST297

5838

113524

188

113644

150

113889

500

114742

5000

NAS1515H3L

Purchased

No

230

Each

380.0000

4

4



WASHER



*Handwritten: 10/11/27*

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

340

111819

94

113362

246

AN960JD816

Purchased

No

250

Each

127.0000

2

2



1/2" washer, Alum



*Handwritten: 10/11/27 10/11/27*

Location

Loc Qty

Loc Code

ST348

127

106043

127

D2744

Manufactured

No

110

Each

14.0000

1

1



Cap



*Handwritten: 10/11/27*

Location

Loc Qty

Loc Code

LG

14

59198

14

*Handwritten: 10/11/27*

Friday, October 01, 2010 10:27:03 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:03 AM

Page 5

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT Manufactured No  
Extrusion Bent

110 Each

8.0000

1 1

Location

Loc Qty

Loc Code

LG 8  
59410 1  
61634 7



①

10-10-13

D2743 Manufactured No  
Crossbolt Spacer

160 Each

230.0000

8 8

Location

Loc Qty

Loc Code

LG 230  
50281 10  
57953 2  
59111 111  
61844 107



8

BE 10/11/08

D2739 Manufactured No  
350 I Beam

160 Each

2.0000

1 1

Location

Loc Qty

Loc Code

LG 2  
61998 2



1

BB 10/11/08

ALS4-1032-225 Purchased No  
Insert

230 Each

4,956.000

4 4

Location

Loc Qty

Loc Code

PK011 4956  
110768 4956



10/11/23

W

Friday, October 01, 2010 10:27:04 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:04 AM

Page 6

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230 Each

33.0000

8

8



Plug Assembly

✓



10/11/23 \*PO = 7

## Location

## Loc Qty

## Loc Code

FP013

33

361987

48

59114

1

61311

32

AN8C35A

Purchased No

230 Each

32.0000

1

1



BOLT

✓



10/11/23

## Location

## Loc Qty

## Loc Code

FP

1

110847

1

ST346

31

114442

6

115188

25

AN6C44A

Purchased No

230 Each

93.0000

4

4



BOLT

✓



10/11/23

## Location

## Loc Qty

## Loc Code

FG

2

103964

2

ST344

91

111649

2

114653

1

114941

75

115030

13

44

Friday, October 01, 2010 10:27:04 AM

Shop Packet Print

Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/23	230	Assemble D3492-041 with D2594-3 "O" ring (+) M114189 huber B 61792	JH	10/11/23	XY		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Friday, October 01, 2010 10:27:04 AM

Page 7

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

✓ Purchased No

230 Each

55.0000

1

1



NUT



✓ 10/11/23

Location

Loc Qty

Loc Code

ST303

55

113845

5

114934

4

115594

46

D3631-1

Manufactured No

230 Each

403.0000

8

8



Washer



✓ 10/11/23

Location

Loc Qty

Loc Code

ST072

129

60755

129

ST076

274

52693

206

54388

68

AN960C10L

NAS1149C0332

Purchased No

230 Each

29.0000

4

4



washer



✓ 10/11/23

Location

Loc Qty

Loc Code

ST245

29

107534

29

M115832

✓ 10/11/23

Friday, October 01, 2010 10:27:04 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:04 AM

Page 8

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

205.0000

8

8



Bushing

✓



10/11/27

Location

Loc Qty

Loc Code

ST023

205

52311

5

59112

4

61203

92

61988

104

230

Each

0.0000

1

AN960C816L (NAS1149C08332R) Purchased

No



WASHER

D3492-043

Manufactured No

230

Each

11.0000

8

8



Plug Assembly

✓



10/11/24 PTO=7

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

9

59117

1

59190

4

61503

4

230

Each

269.0000

4

4

AN3C6A

Purchased

No



BOLT

✓



10/11/24

Location

Loc Qty

Loc Code

ST351

269

111982

269

Y4

Friday, October 01, 2010 10:27:04 AM

Shop Packet Print

Page 8

Dart Aerospace Ltd

W/O: 62438		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/24	236	Assemble D3492-043 Plugs with NAS1611-013 "8" Rings. (+) M114189 Lube	W	10/11/24	x8		5 10/11/24

Part No: D350-636-016 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Friday, October 01, 2010 10:27:04 AM

Page 9

Work Order ID: 62438

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No



NUT

230 Each 642.0000 4 4  
 10/1/2010

## Location

## Loc Qty

## Loc Code

ST301

642

112314

642

ST301

642

D3493-1 Manufactured No



Washer

250 Each 48.0000 2 2  
 10/1/2010

## Location

## Loc Qty

## Loc Code

ST062

40

61672

40

ST065

8

60873

8

MS21083C8 Purchased No



NUT

250 Each 55.0000 1 2  
 10/1/2010

## Location

## Loc Qty

## Loc Code

ST303

55

113845

5

114934

4

115594

46

AN8C21A Purchased No



BOLT

250 Each 57.0000 2 12  
 11/14/2010

## Location

## Loc Qty

## Loc Code

ST345

57

113558

1

114653

16

115723

40

Friday, October 01, 2010 10:27:04 AM

Shop Packet Print

Page 9

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 10

Friday, October 01, 2010 10:27:04 AM

Work Order ID: 62438



Parent Item: D350-636-016



Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 9/30/2010

Required Date: 10/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

37.0000

1

1



Blade, 350 Skidtube



10/11/2010

Location

Loc Qty

Loc Code

ST466

37

60210

37

1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 62438
Description: 350 Skid/Training Weights		Part Number: 1350-636- <del>1016</del> /016
Inspection Dwg: D4168	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
112.48	+/- 0.030	112.46	✓			
49.210	+/- 0.010	49.210	✓			
56.150	+/- 0.010	56.15	✓			
2.60	+/- 0.030	2.45		✓		
22.440	+/- 0.010	22.440	✓			
R30.0	+/- 1.00	R30.0	✓			
5.860	+/- 0.010	5.860	✓			
12.990	+/- 0.010	12.990	✓			
4.330 <del>2.990</del>	+/- 0.010	4.330	✓			
20.865	+/- 0.010	20.865	✓			
11.73	+/- 0.030	11.75	✓			
28°	+/- 1/2°	29°		✓		3 OK 10.11.02
12.000	+/- 0.010	12.000	✓			
8.750	+/- 0.010	8.750	✓			
14.750	+/- 0.010	14.750	✓			
0.550	+/- 0.020	0.530	✓			
2.480	+/- 0.010	2.480	✓			
15.47	+/- 0.030	15.47	✓			
40.76	+/- 0.030	40.76	✓			
66.54	+/- 0.030	66.54	✓			
89.98	+/- 0.030	89.98	✓			

Measured by: DP	Audited by: S	Prototype Approval:	N/A
Date: 10-10-13	Date: 10/14/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: 350 Skid/Training Wenghtes		Part Number:	D350-636-016
Inspection Dwg: D4168	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>Detail J</u>						
0.84	+/- 0.030	0.84	✓			
2.770	+/- 0.010	2.770	✓			
2.77	+/- 0.030	2.77	✓			
<u>Detail K</u>						
1.770	+/- 0.010	1.770	✓			
3.940	"	3.940	✓			
1.770	"	1.770	✓			
<u>Detail L</u>						
1.180	+/- 0.010	1.180	✓			
3.150	"	3.150	✓			
1.180	"	1.180	✓			
<u>Detail M</u>						
1.180	+/- 0.010	1.180	✓			
3.150	"	3.150	✓			
1.180	"	1.180	✓			

Measured by: DP	Audited by: 8	Prototype Approval:	N/A
Date: 10-10-13	Date: 10/10/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: <u>350 SB-2 w/ Training Weights</u>		Part Number:	<u>D350-636-016</u>
Inspection Dwg: <u>D4168</u> Rev: <u>A</u>		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>Section N-N</u>						
23.5°	+/- 1/2°	24.2°		✓		3OK UP 10/11/02
23.5°	"	24.2°		✓		
<u>Section Q-Q</u>						
17°	+/- 1/2°	16.5	✓			
17°	"	16.5	✓			
17°	"	16.5	✓			
17°	"	16.5	✓			
<u>Section R-R</u>						
17°	+/- 1/2°	16.8	✓			
17°	"	16.8	✓			
17°	"	16.8	✓			
17°	"	16.8	✓			

Measured by: <u>DP</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-10-13</u>	Date: <u>10/11/02</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

2011/012  
2013/014  
2015/016  
2017/018



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
  - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
  - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
  - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
  - MINIMUM YIELD TENSILE STRENGTH = 35 KSI
  - MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- 11) POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

STANDARD COPY  
REVISION  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO REVISION  
WHICH MAY BE  
WITHDRAWN  
NO. 62438  
BS 10-10-09

RELEASED  
R 2010-09-15 D

A	NEW ISSUE	DESCRIPTION	SC	10.08.09
REV.			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4168	SHEET 1 OF 11	
APPROVED		TITLE	SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS	
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

**Dart Aerospace Ltd**

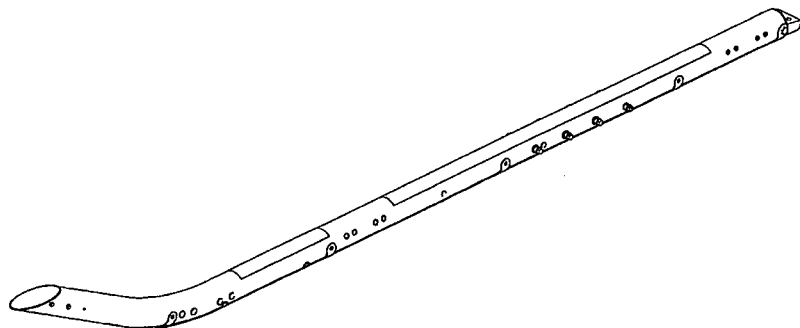
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

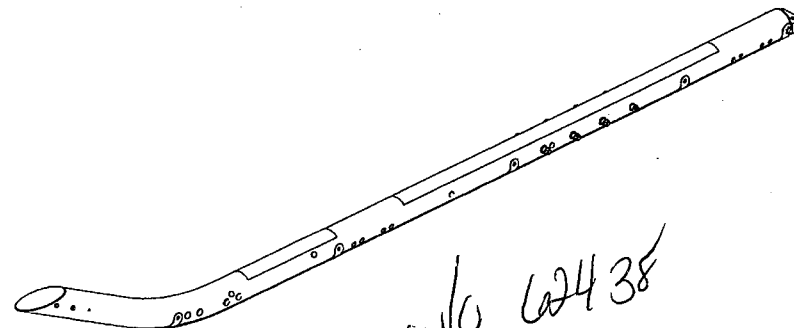
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



*w/o 62438*

**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2010-09-15  
JW

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4168</b>	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>10.08.09</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROVIDED AS IS AND DOES NOT WARRANT, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



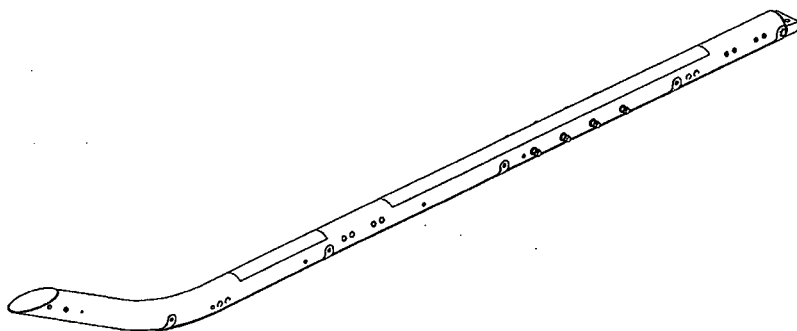
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

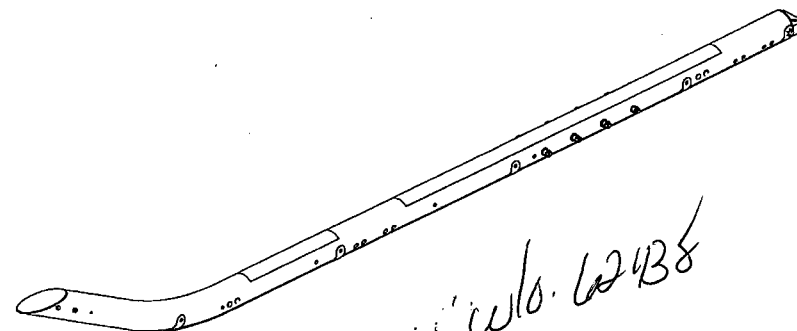
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4168</b>	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>10.08.09</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

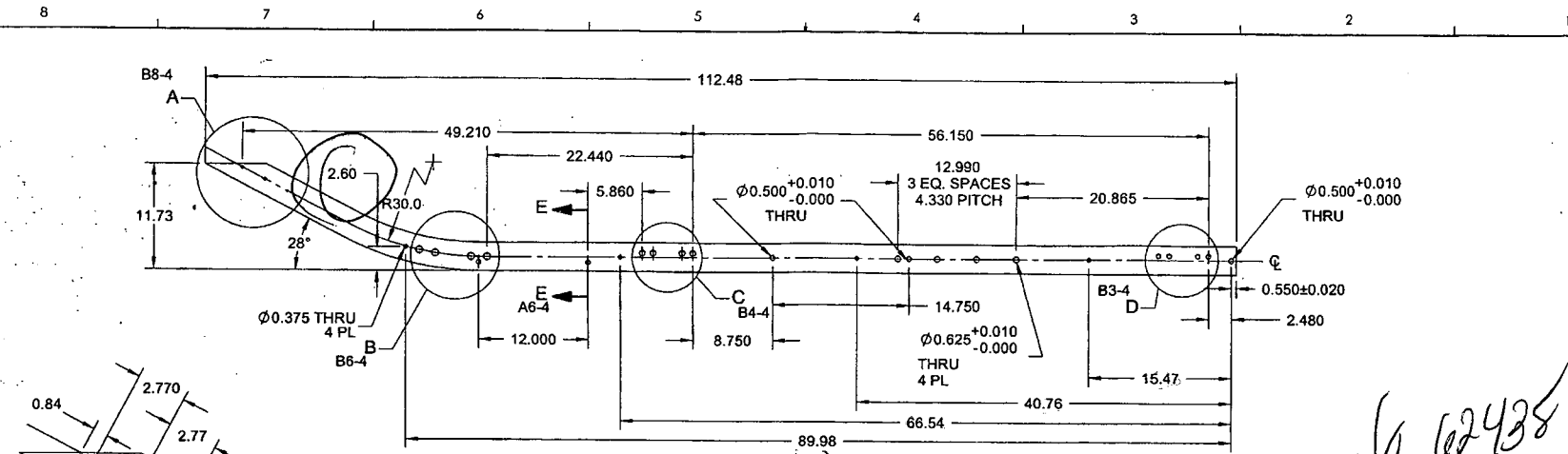
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

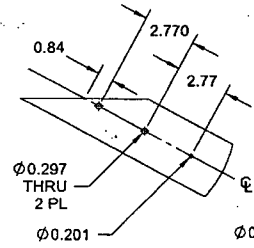
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

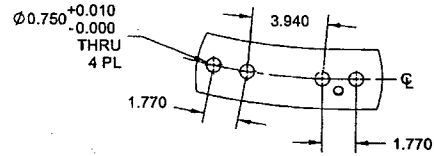
**NOTE:** Date & initial all entries



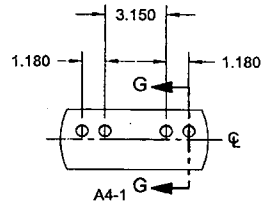
**D4168-1 LH SKIDTUBE**



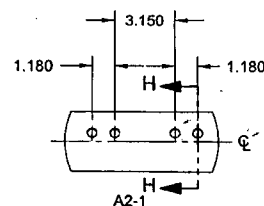
**DETAIL A**  
SCALE 2X



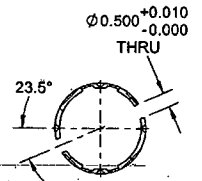
**DETAIL B**  
SCALE 2X



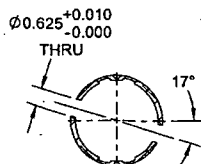
**DETAIL C**  
SCALE 2X



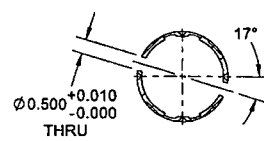
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4168</b>	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>10.08.09</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

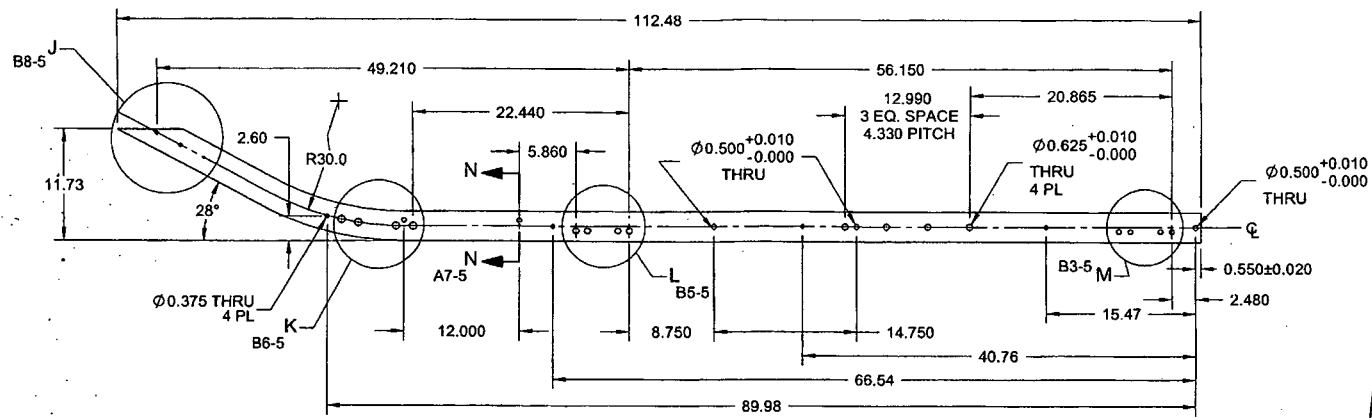
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

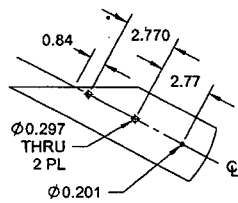
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

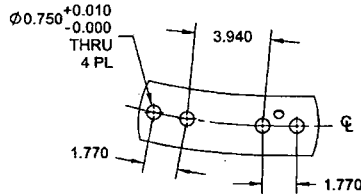
8 7 6 5 4 3 2 1



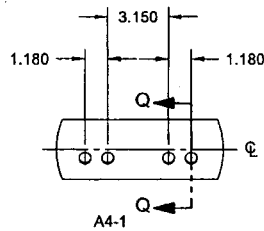
**D4168-2 RH SKIDTUBE**



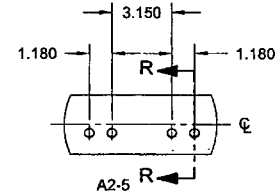
**DETAIL J**  
SCALE 2X



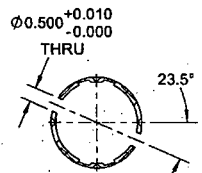
**DETAIL K**  
SCALE 2X



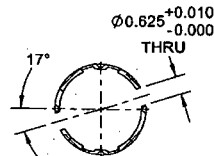
**DETAIL L**  
SCALE 2X



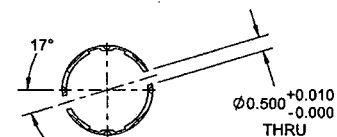
**DETAIL M**  
SCALE 2X



**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

*WLO. 624B8*

**RELEASED**  
2010-09-15  
*MD*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

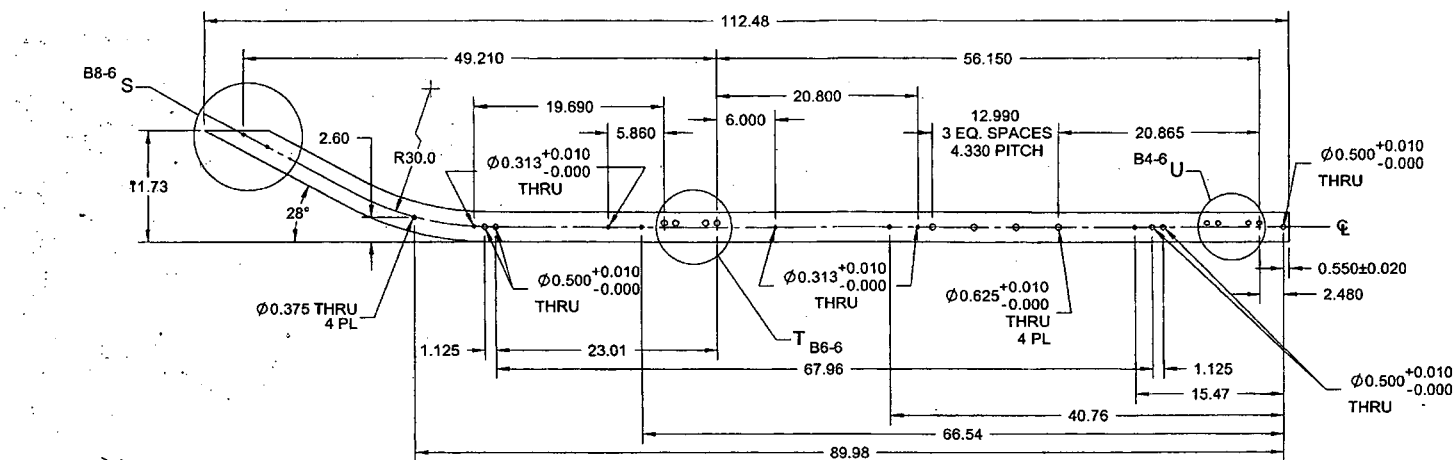
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

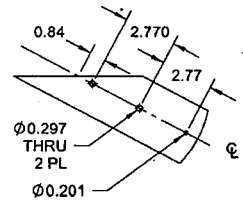
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

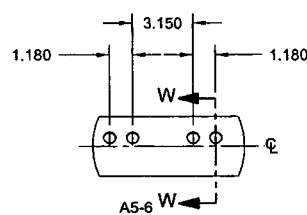
8 7 6 5 4 3 2 1



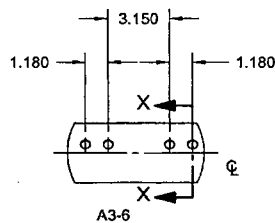
**D4168-3 LH SKIDTUBE**



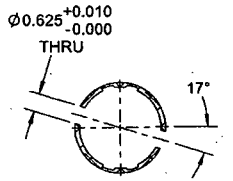
**DETAIL S**  
SCALE 2X



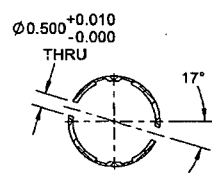
**DETAIL T**  
SCALE 2X



**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

*u/o 62435*

**RELEASED**  
2010-09-15  
MM

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

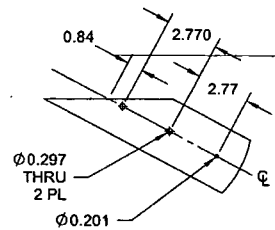
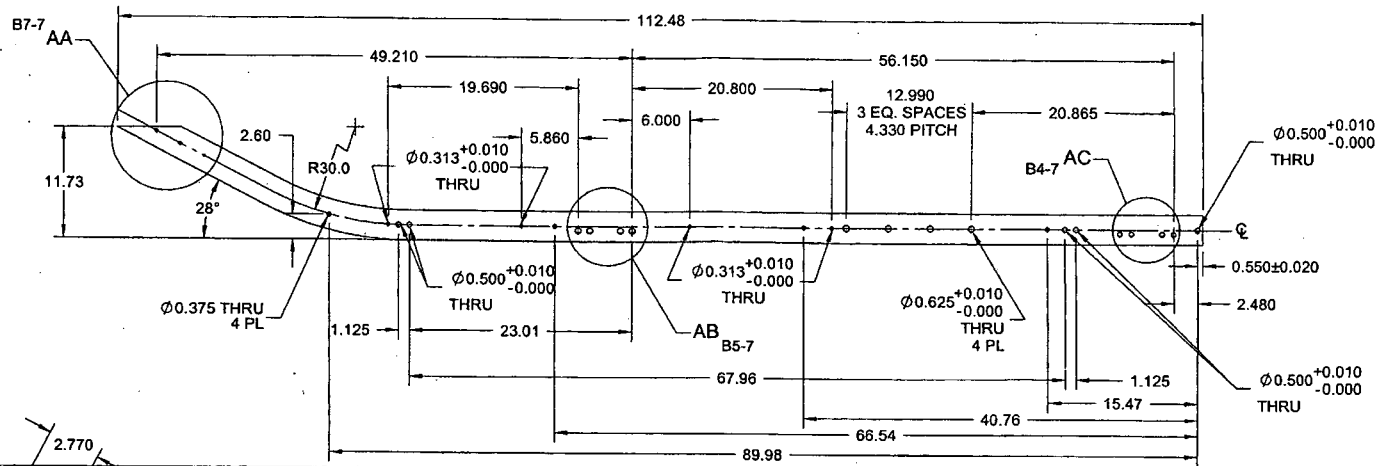
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

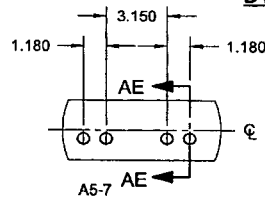
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

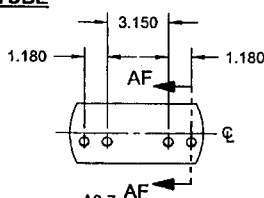
8 7 6 5 4 3 2 1



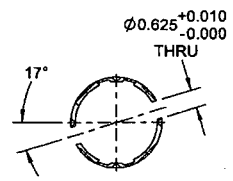
**DETAIL AA**  
SCALE 2X



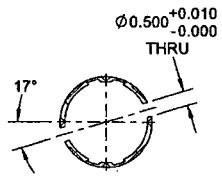
**DETAIL AB**  
SCALE 2X



**DETAIL AC**  
SCALE 2X



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*w/o 62438*

**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

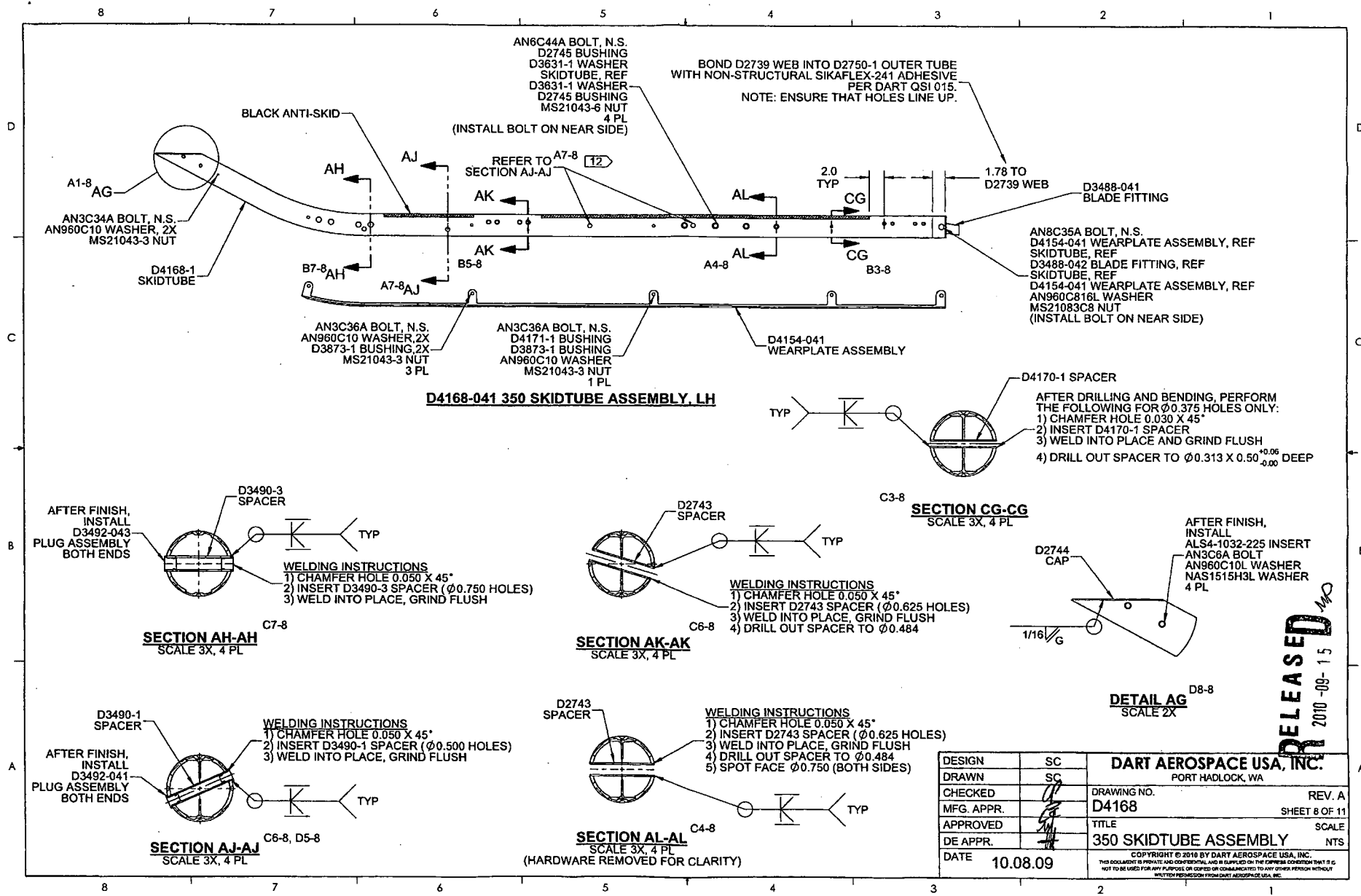
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

WLS 62435



RELEASED  
2010-09-15

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4168	SHEET 8 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

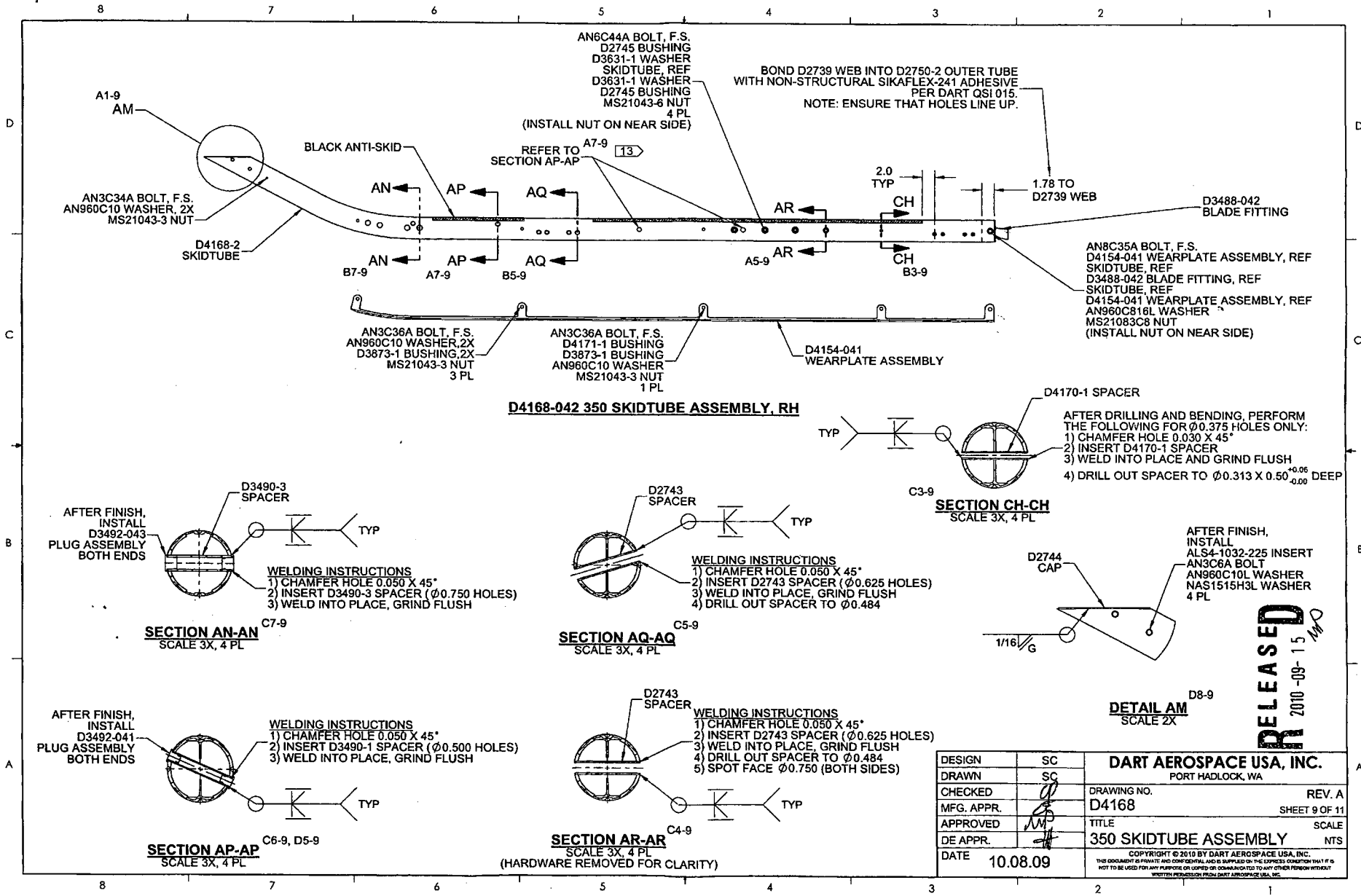
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

20 02435



RELEASED  
2010-09-15  
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D4168-043 350 SKIDTUBE ASSEMBLY, LH**

**SECTION CJ-CJ**  
SCALE 3X, 4 PL

**SECTION AT-AT**  
SCALE 3X, 4 PL

**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**SECTION AU-AU**  
SCALE 3X, 4 PL

**SECTION AW-AW**  
SCALE 3X, 4 PL

**DETAIL AS**  
SCALE 2X

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
DRAWN	SC	
CHECKED	ID	
MFG. APPR.	[Signature]	
APPROVED	[Signature]	
DE APPR.	[Signature]	TITLE
DATE	10.08.09	D4168
		350 SKIDTUBE ASSEMBLY
		SHEET 10 OF 11
		SCALE
		NTS

**RELEASED**  
R 2010-09-15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

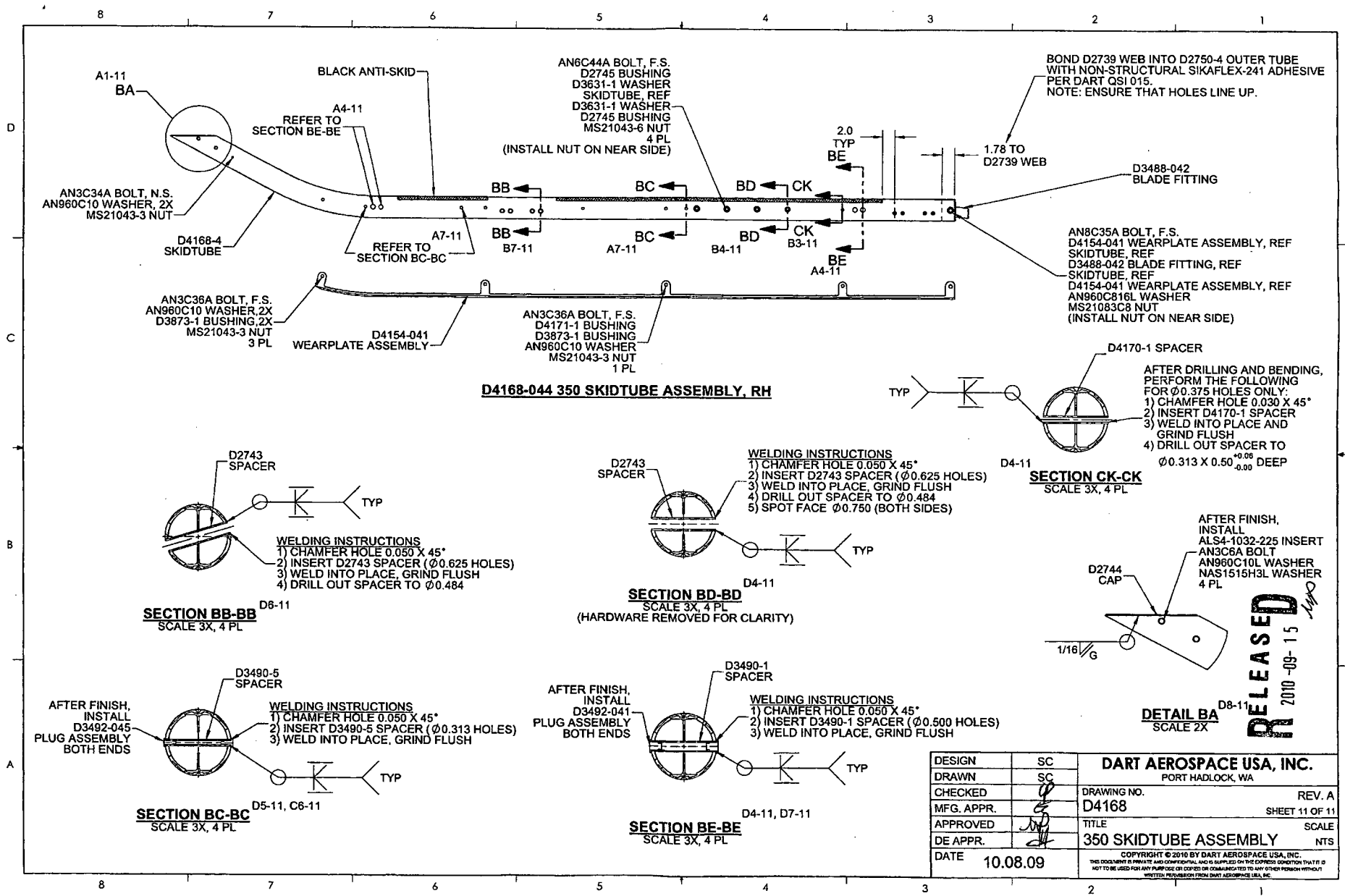
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_





Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W662438



DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED  
2010-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# 8.0 PARTS LIST (D350-636-015/-016/-017/-018/-047 KITS)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
	X					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
		X				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
			X			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
				X		D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
					X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1					D4168-041	SKIDTUBE ASSEMBLY, LH
1		1				D4168-042	SKIDTUBE ASSEMBLY, RH
1			1			D4168-043	SKIDTUBE ASSEMBLY, LH
1				1		D4168-044	SKIDTUBE ASSEMBLY, RH
*1	1					D4168-1	SKIDTUBE WELDMENT, LH
*1		1				D4168-2	SKIDTUBE WELDMENT, RH
*1			1			D4168-3	SKIDTUBE WELDMENT, LH
*1				1		D4168-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1					AN8C35A	BOLT
*6A	1					AN968C816L	WASHER (OR NAS1149CO832R)
*7	1					MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8				1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN968JD816	WASHER (OR NAS1149CO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4					AN6C44A	BOLT
*15	8					D2745	BUSHING
*16	4					MS21043-6	NUT
*17	8					D8631-1	WASHER
*18	4					AK34-1032-225	INSERT
*19	4					AN3C8A	BOLT
*20A	4					AN968C10L	WASHER (OR NAS1149CO332R)
*20B	4					NAS1515H3L	WASHER
*30	8					D3492-041	PLUG ASSEMBLY
*31	8					D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1	1	<del>D4154-041</del>	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	<del>AN3C36A</del>	BOLT <sup>1</sup>
91B	1	1	1	1	1	<del>AN3C37A</del>	BOLT <sup>2</sup>
91C	1	1	1	1	1	<del>AN3C42A</del>	BOLT <sup>3</sup>
*92	7	7	7	7	8	<del>AN960C10</del>	WASHER (OR NAS1149CO363R)
92A			1	1		AN960C10	WASHER (OR NAS1149CO363R) <sup>3</sup>
*93	4	4	4	4	4	<del>MS21043-3</del>	NUT
*94	7	7	7	7	8	<del>D3873-1</del>	BUSHING
94A			1	1		D3873-1	BUSHING <sup>3</sup>
*95	1	1	1	1	1	<del>D4171-1</del>	BUSHING <sup>4</sup>
*96	4	4	4	4	4	<del>D4170-1</del>	SPACER
*97	1	1	1	1	1	<del>AN3C34A</del>	BOLT
*98	2	2	2	2	2	<del>AN960C10</del>	WASHER (OR NAS1149CO363R)
*99	1	1	1	1	1	<del>MS21043-3</del>	NUT

\* PART OF D4168-041/-042/-043/-044

\*\* TO BE SUPPLIED BY CUSTOMER

\*\*\* ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

<sup>1</sup> QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS<sup>2</sup> HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS<sup>3</sup> HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS<sup>4</sup> HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: H

Date: 10.07.26

NO. 239

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 6194 61914  
Part number: D350-636-012  
Description: 350 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. J. Day Date of Test Coupon 10.09.30  
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld